

Date: Wednesday, 5/16/2007 8:13:29 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: LUG BRACKET	
Job Number	: 32376B		Part Number	: D2658	
Estimate Number	: 10339		Drawing Number	: D2658 REV D	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 5/16/2007 S.O. No. : N/A		Drawing Revision	: D	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 6/6/2007	
Previous Run	: 32018B		Qty:	32	Um: Each
Written By					
Checked & Approved By					
Comment	: Est Rev:A New Issue 05-11-07 JLM				
	Est Rev:B Now on Waterjet 06-08-23 JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :		
1.0	M1010S12GA	1010/1025/A21/6aA SHEET		
		Comment: Qty.: 0.1197 sf(s)/Unit Total : 3.8304 sf(s) 1010/1025/A21/6aA SHEET 12 GAUGE .100" THK Batch: M104 28	SAD	07/06/12
2.0	WATER JET	FLOW WATER JET		
		Comment: FLOW WATER JET 1-Cut as per Dwg D2858 Dwg Rev: D Prog Rev: D		
		2-Deburr if necessary	SAD	07/06/12
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE		
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	SAD	07/06/12
4.0	QC8	SECOND CHECK		
		Comment: SECOND CHECK	SAD	07/06/12
5.0	BRAKE NC	NC BRAKE		
		Comment: NC BRAKE 1-Deburr as required.	SAD	07/06/18
		2-Bend on CNC brake using DT8254Identify as D2658	SAD	07/06/18

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes Yes No DQA: D Date: 07/06/05
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: LUG BRACKET

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Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

1/16/07 07/06/18

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: NA

FC 07/06/21 (32)

8.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

1/16/07 07/06/25

Job Completion



u 07/06/25

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	32376B
Description: Lug Bracket	Part Number:	D2658
Inspection Dwg: D2658	Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	SAD	Audited by:	EW	Prototype Approval:	N/A
Date:	07/06/12	Date:	07/06/12	Date:	N/A

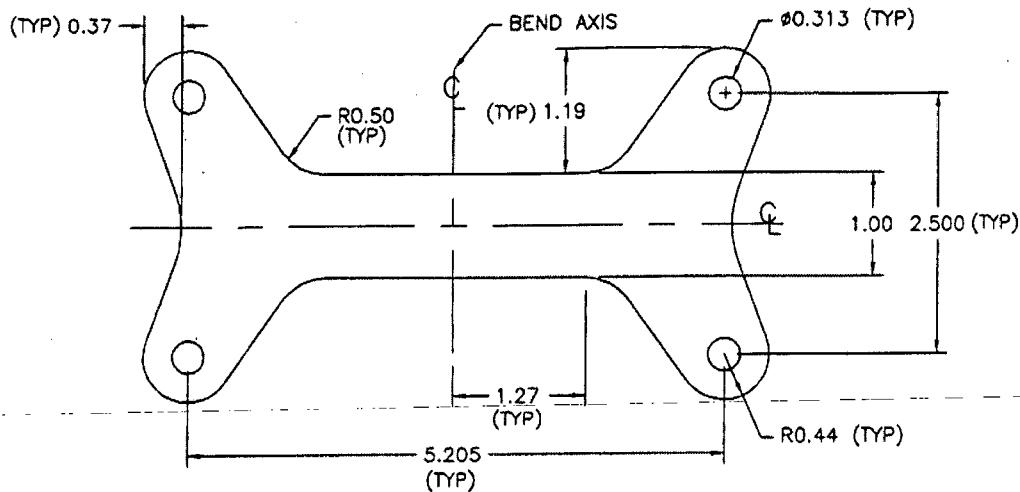
Rev	Date	Change	Revised by	Approved
A	06.11.13	New Issue	KJ/JLM	SP/

DART

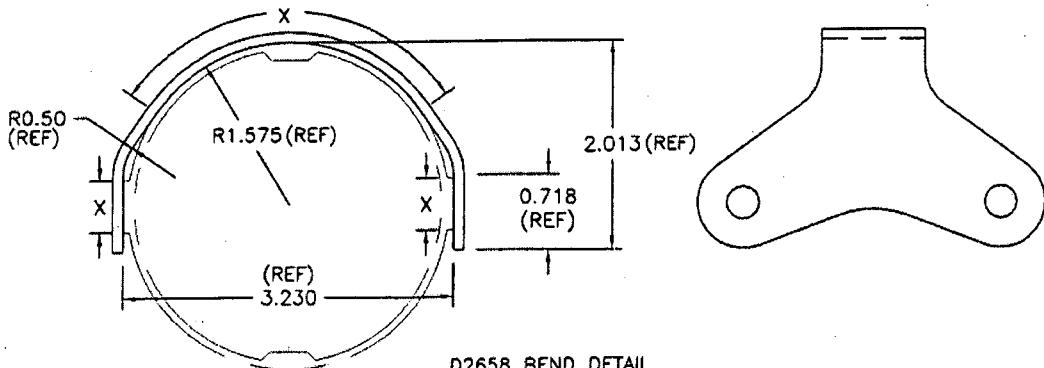
COPY ISSUED
10

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2658
		REV. D SHEET 1 OF 1
DATE		TITLE LUG BRACKET
98.12.14		SCALE 5:9
A	97.11.03	NEW ISSUE
B	97.12.18	5.205 WAS 5.015, ADD TOOLING HOLE
C	98.10.23	UPDATE MATERIAL (TSR A1114)
D	98.12.14	REMOVE TOOLING HOLE (TSR A1040)

RELEASED
98.12.14 DS



D2658 FLAT PATTERN
SYMMETRICAL ABOUT BOTH CENTRE-LINES (C)



D2658 BEND DETAIL

D2658 SHOULD BE BENT SO THAT IT IS WITHIN 0.010 OF THE OUTSIDE PROFILE
OF THE D2600-1 EXTRUSION IN THE AREAS INDICATED 'X' ABOVE.

GENERAL NOTES
MATERIAL: ASTM A36/A366/A569/A570 OR AISI 1010-1025 STEEL 0.100 THICK (12 GAUGE)
MIN. ULTIMATE TENSILE STRENGTH = 42 ksi
MIN. YIELD TENSILE STRENGTH = 28 ksi

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 32376.B